

ABSTRACT

A dressing method capable of dressing the grinding stone of a vertical duplex-head surface grinding machine without incorporating a special dressing device therein. The vertical duplex-head surface grinding machine comprises a pair of upper and lower grinding wheels (2) and (3) rotated around the vertical axis thereof and a work holding part (9) holding a work at a specified position and rotatable on its vertical axis. The work holding part (9) further comprises first and second reference planes (31) and (32) for positioning the work, and the first reference plane (31) is formed of a circular surface positioned concentrically to the self-rotating axis (O2) of the work holding part (9) and the second reference part (32) is formed of a plane positioned orthogonal to the self-rotating axis. A dressing tool comprises a fitting part (62) fitted to the first reference plane and a abutment surface (62d) in contact with the second reference plane. The fitting part (62) is fitted to the first reference plane (31) and the abutment surface (62d) is brought into contact with the second reference plane (32) to position the dressing tool. Under the positioned state, the dressing tool is fitted to the work holding part (9) and the dressing of the grinding stone is started.